

Bakel
Ppg.

Work Order ID 63795

Monday, November 15, 2010 8:30:38 AM

Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 11/12/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-11-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B 10-11-16

16

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

SL 10/12/03 / SL 10/11/07

16

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/11/07

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Monday, November 15, 2010 8:30:43 AM

Page 1

Work Order ID: 63795

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw




Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 16.00

Required Qty: 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	183.2114	3.7	59.2			

Location

Loc Qty

Loc Code

MAT

183.2114

114624

5.9054

115325

15.506

115955

161.8

115955

(16)

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DART AEROSPACE LTD		Work Order:	63791
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

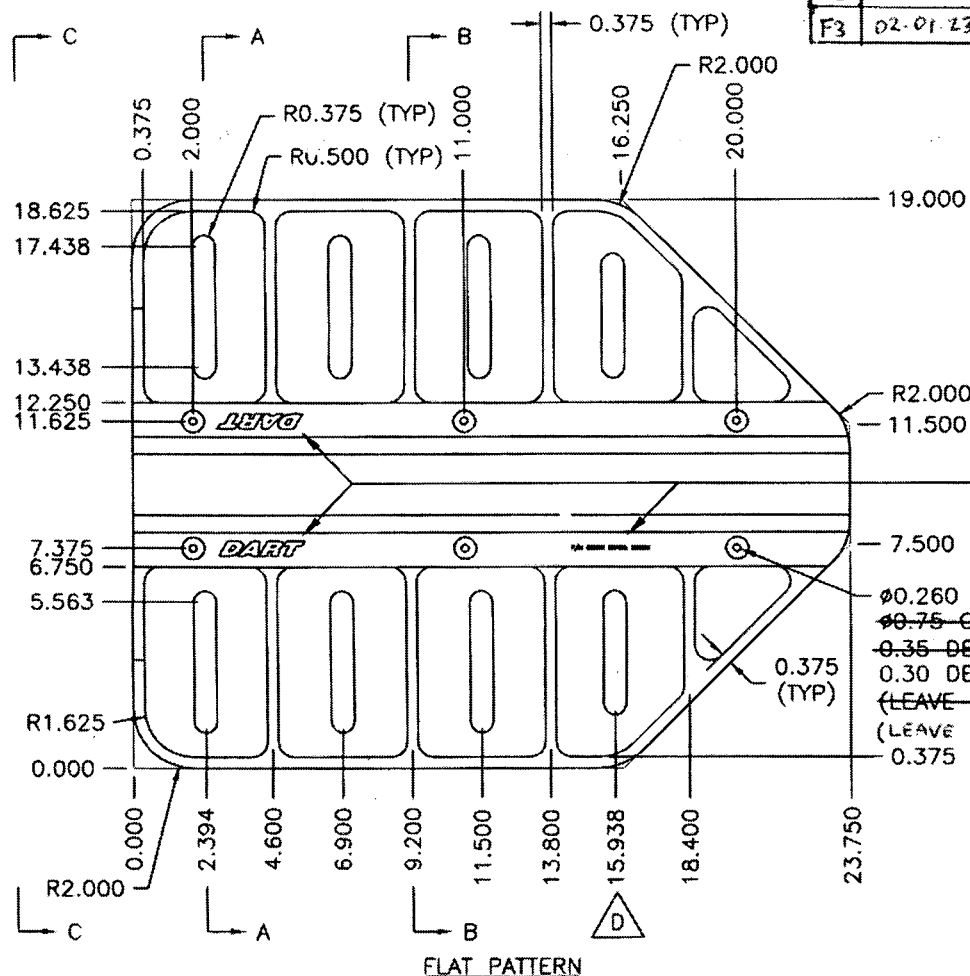
☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	.055X45°	—		Vern	ML-7
B 5.500	+/-0.030	5.505	—		"	"
C 0.200	+/-0.030	.203	—		"	"
D 0.25 x 45°	+/-0.030	.237X45°	—		"	"
E R0.250	+/-0.030	R.250	—		Rad-gage	REF
F 0.250	+/-0.010	.252	—		Vern	ML-2
G 0.625	+/-0.030	.630	—		"	"
H 0.375	+/-0.010	.385	—		"	"
I 0.950	+0.030/0.010	.962	—		"	"
J 19.000	+/-0.030	19.000	—		M-tape	ML-2
K 3.14	+/-0.030	3.145	—		Vern	ML-7
L 3.28	+/-0.030	3.288	—		"	"
M Ø0.260	+0.005/-0.000	Ø.260	—		"	"
N Ø0.93	+/-0.030	Ø.925	—		"	"
O 0.30	+0.030/-0.000	.309	—		"	"
P 23.750	+/-0.030	23.750	—		M-tape	ML-2
Q 7.375	+/-0.030	7.375	—		"	"
R 4.250	+/-0.010	4.250	—		"	"
S 2.000	+/-0.030	2.000	—		"	"
T 9.000	+/-0.010	9.000	—		"	"
U 9.000	+/-0.010	9.000	—		"	"
V 0.375	+/-0.010	.381	—		Vern	ML-2

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	10/12/02	Date:	10-12-07	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

EFFECTIVE	DEOS
9143	

DESIGN KE		DRAWN BY KE		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED MM		APPROVED D		DRAWING NO. D2432	
DATE 98.05.12		TITLE BEARPAW		REV. F SHEET 1 OF 2	
				SCALE 1:6	
A		95.10.31	NEW ISSUE		
B		96.01.24	RE-DESIGN		
C		96.03.26	CHANGE BORE AND C'BORE DEPTH		
D		96.06.04	MOVE SLOT		
E		97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS		
F		98.05.12	CHANGE C'BORE, ADD B AND F P/N		

RELEASED
98.06.17 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITH NOTICE
WORK ORDER
NO. 13745
10-11-15



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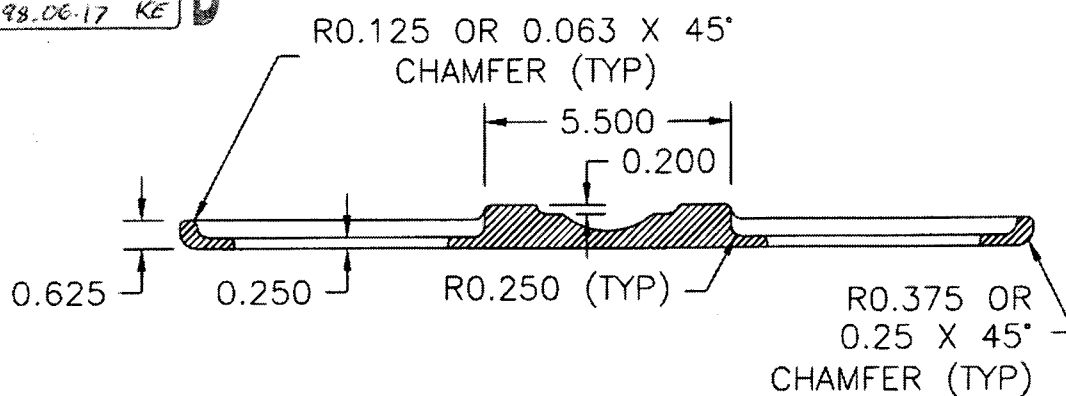
NOTE: Date & initial all entries



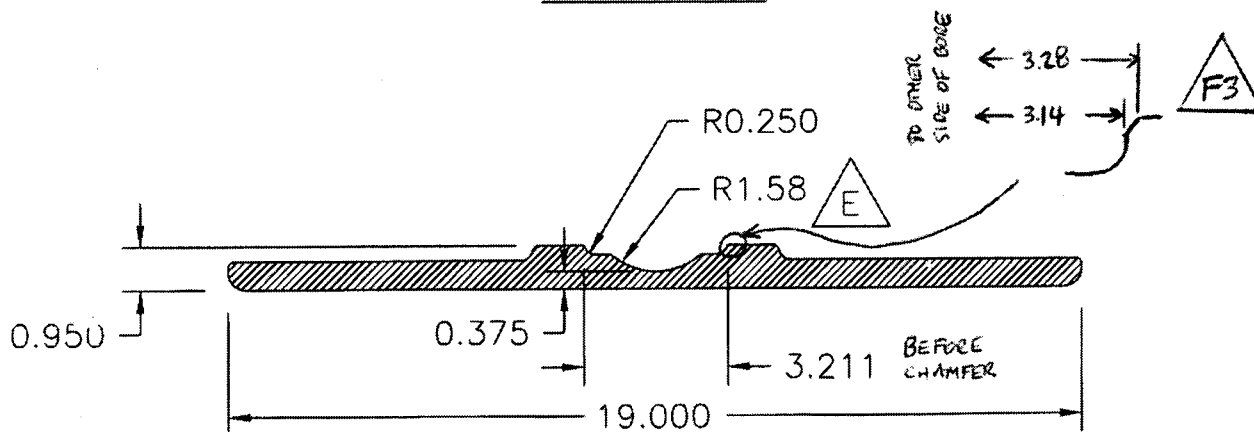
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

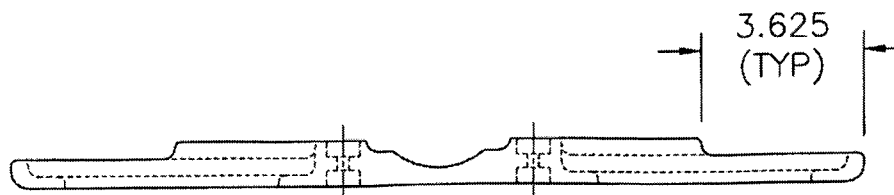
a/b 63795



SECTION A-A



SECTION B-B



SECTION C-C

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